

Date: Thursday, 20/11/2008 3:35:21 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLACARD
Job Number : 43623	
Estimate Number : 11149	
P.O. Number :	Part Number : D32141
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3214 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 37103	Material :
Written By :	Due Date : 28/11/2008 Qty: 16 Um: Each
Checked & Approved By : <u>JLD 08.11.21</u>	
Comment : Est. A04.04.15 New issue KJ/RF Est Rev:B Now 6061-T6 06-06-23 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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1.248



Comment: Qty.: ~~0.0780~~sf(s)/Unit Total: ~~0.7802~~sf(s)
 5052-H32 .080 Sheet
 Material: 6061-T6 0.080" thick or 5052 H32 0.080" thick
 (M6061-T6S.080) or (M5052H32S080)
 Identify for D3214-1
 Batch: M110063

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: 3.70" x 2.70"
 Drill hole and fillet corner as per Dwg D3214
 Deburr
 Identify as D3214-1

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



M 10 S 642



(16X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10 = 30
320 OF
11 = 00

M-F 08/12/17

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(16)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/12/17

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Engrave text as per Folio FA394 and Dwg D3214

JL 08/12/29

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/12/29

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J-F 08/12/29 (16)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST77

JS 08/12/30

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

AD 08/01/05
MUF 08-12-31

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN T#	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3214	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE PLACARD	SCALE 1:1
A	04.01.27	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED
06.06.20 [Signature]

**D3214-1****NOTES**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.1
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43023

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